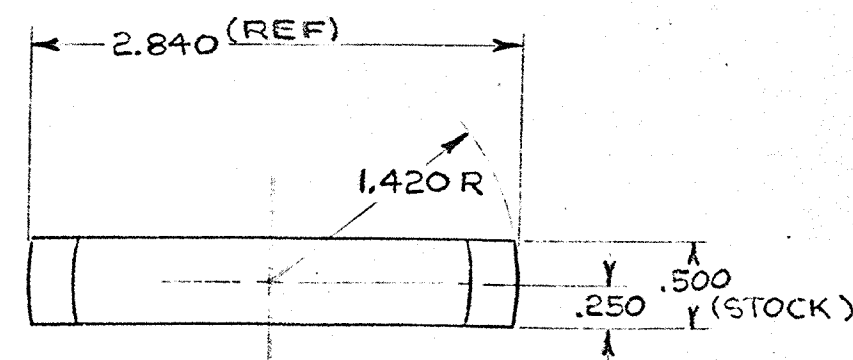
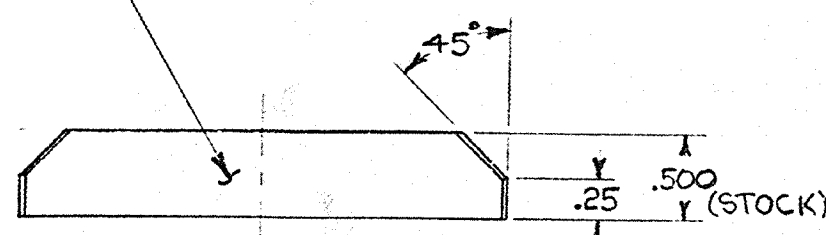


A ADD YH-40 TO N/A BLOCK &
INC. E.O. 204A1671 9-17-57 *H.C. Miller*
B SEE E.O. 204 AA 2276 11-27-57 *H.C. Miller* E.GREEN
C SEE E.O. 204 CB-798; CHG. N/A BLOCK
TO SHOW HU-1 & Added HU-1A 2-2-59 *H.C. Miller* E.GREEN



STEEL STAMP "UST101333"
PER BPS FW4050. USE
3/16 IN. FIGURES



TOOL USAGE BLOCK							
COLUMN	V2	V3	V4	V5	V6	V7	V8
PARAGRAPH	REMARKS	TOOL NUMBERS	OPERATION	PART NUMBER & NAME	OPERATION	PART NUMBER & NAME	OF ASSEMBLY NUMBER
① I		T101333	REMOVE	204-040-144 BEARING	FROM	204-040-160 or 204-040-305 SLEEVE ASSY	204-040-003
① II		T101333	REMOVE	204-040-144 BEARING	FROM	204-040-160 or 204-040-305 SLEEVE ASSY	204-040-206
① III		T101333	REMOVE	204-040-144 BEARING	FROM	204-040-160 or 204-040-305 SLEEVE ASSY	204-040-207
① IV		T101333	REMOVE	204-040-144 BEARING	FROM	204-040-161 or 204-040-306 SLEEVE ASSY	204-040-208
① V		T101333	REMOVE	204-040-407 BEARING	FROM	204-040-404 SLEEVE ASSY	204-040-004
① VI		T101333	REMOVE	204-040-407 BEARING	FROM	204-040-414 or 204-040-419 SLEEVE ASSY	204-040-004

T101333

C

② HEAT TREAT TO 160,000-180,000 PSI TENSILE
STRENGTH, ROCKWELL Rc 36-40.

I. BREAK SHARP CORNERS .015-.032

NOTES:

DASH NO.	NEXT ASSY	USED ON
204-040-208	HU-1A	REF REF
204-040-207	HU-1A	REF REF

T101333 BAR				STEEL 4130 BAR MIL-S-6758 D-4				1/2 1/2 3.1 ② FE CC2 551			
FLAG	PART NUMBER	PART NAME	MATERIAL	STOCK	GOVT SPEC	DATE	FILE	WIDTH	LOD	FILE	FILE
NO. ASSY NOTE	204-040-206	HU-1A	REF REF	204-040-004	XH-40	REF REF					
	204-040-004	HU-1A	REF REF	204-040-208	YH-40	REF REF					
	204-040-003	HU-1A	REF REF	204-040-207	YH-40	REF REF					
	204-040-208	HU-1	REF REF	204-040-206	YH-40	REF REF					
	204-040-207	HU-1	REF REF	204-040-003	YH-40	REF REF					
	204-040-206	HU-1	REF REF	204-040-208	XH-40	REF REF					
	204-040-004	HU-1	REF REF	204-040-207	XH-40	REF REF					
	204-040-003	HU-1	REF REF	204-040-206	XH-40	REF REF					
	204-040-004	YH-40	REF REF	204-040-003	XH-40	REF REF					
DASH NO.	NEXT ASSY	USED ON	NEXT ASSY	FINAL ASSY	DASH NO.	NEXT ASSY	USED ON	NEXT ASSY	FINAL ASSY	DASH NO.	NEXT ASSY
		APPLICATION		QTY. REQD.			APPLICATION		QTY. REQD.		

LIST OF MATERIAL

299-099-031

ALL DIMENSIONS ARE IN INCHES

UNLESS OTHERWISE SPECIFIED

TO BE PLACED ON

DELIMITERS

ANGLES

MACHINING SURFACES

125

FINISH AS NOTED

18-24

BAR.
ROLLER BEARING REMOVAL,
TAIL ROTOR & ACCESS DRIVE
QUILLS,
TRANSMISSION & 42° GEAR BOX

T101333

FULL BPS FW4140 MIL-H-6875

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